

**Work Order ID 56272**

Wednesday, February 17, 2010 11:05:48 AM

Page 1

Item ID: D350-589-011

Accept

Revision ID:

Item Name: Side Door Latch Modification

Start Date: 2/18/2010 Start Qty: 4.00

Required Date: 3/4/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: MF

Date: 10-2-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

8/10/12/18

MF 10/02/18

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-2-17 sf 6x

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

7/8/12/18

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per QSI 014

Rev F

102-18

(6x) SC

130

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/02/18

MF

10-2-18

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# Picklist Print

Wednesday, February 17, 2010 11:05:48 AM

Page 1

Work Order ID: 56272

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Comments: IPP F002.08.29 Removed D2587 Plug [KJ]  
ALL AT CHANGE 002

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer	x3	Purchased	No	QSI	OMF SL	105	Each	0.0000	12.0000			
D2237 Striker Plate	x3	Manufactured	No			105	Each	114.0000	12.0000			

M1132 58 10-2-17 SL  
10-2-17 SL

## Warehouse Location

Location	Loc Qty	Loc Code
Main Warehouse		
ST	30	
55006	30	
Main Warehouse		
ST010	52	
46162	5	
55312	47	

Main Warehouse		
ST022	32	
52327	32	
105	Each	69.0000
		12.0000

18  
10-2-18 SL (6x)

D2583 x3

Latch Bracket

## Warehouse Location

Location	Loc Qty	Loc Code
Main Warehouse		
ST018	69	
36043	2	
53889	12	
55321	55	

12  
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 56272

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585 Mounting Channel		Manufactured	No			105	Each	123.0000	12.0000	18	10-2-17	SL

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

51526

2

Main Warehouse

ST018

121

45888

2

53798

59

55313

60

Manufactured No

105

Each

60.0000

12.0000

10-2-17

SL (6x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

45554

1

50213

59

18

D2586

Door Latch

Wednesday, February 17, 2010 11:05:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 4.00 **6**

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2587 <b>xl</b>  Door Slug, 350 Hinge		Manufactured	No			105	Each	37.0000	4.0000 <b>6</b>		<b>10-2-17</b> <b>sl</b>	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST018

37

**48647**

37

105

Each

42.0000

4.0000

**18**

**6**



**3x each**

**10-2-17**

**sl**

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST019

42

**46840**

2

**50378**

40

105

Each

1,889.000

24.0000

**6x**

**2**

**16**



**10-2-17**

**sl @**

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1889

**106918**

50

**111916**

1839

**36**

MS20470AD4-5 **xl**

Purchased

No



Rivet, Universal Head

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Side Door Latch Modification

Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			105	Each	2,665.000	12.0000	3X		



Nut



18.

10-2-17 S

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2659	
110844	35	
111274	27	
111668	52	
112314	289	
112385	498	
113523	58	18
113537	700	
113644	1000	

Main Warehouse

ST139	6	
111668	6	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 2/18/2010

Required Date: 3/4/2010

Comments: IPP F02.08.29 Removed D2587 Plug KJ  
ALL AT CHANGE 002

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15	83	Purchased	No			105	Each	124.0000	12.0000	3x		



Screw

10-2-17 sl 6x

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

106903

108169

109321

111916

112794

124

3

4

4

13

100

3x  
15x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**REFERENCE ONLY**

8

**52.4 PARTS LIST**

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

\* Reference only. Included in D3085-041 Prop Assembly listed above.

\*\* Reference only. Included in D2991-1/-2/-3 Doors listed above.

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